

# Work Order ID 82171

Friday, March 23, 2012 1:29:23 PM

**\*82171\***

Page 1

Item ID: D3793-1

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Wearshoe

Start Date: 3/23/2012 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals: Process Plan:

Date: 12-03-23 Tooling:

Date:

Stop

**\*NR2\***

QC:

Date: SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3793	Rev A

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793 Dwg Rev: A Prog Rev: A 2-  
Deburr if necessary

364.040

*Jm* / *nl* 12 04 02 (16)

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*Jm* / *nl* 12 04 02 (16)

120

0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Siz/oloz*

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82171

Friday, March 23, 2012 1:29:23 PM

**\*82171\***

Page 2

Item ID: D3793-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearshoe  
 Start Date: 3/23/2012 Start Qty: 16.00 **\*16\*** Cust Item ID:  
 Required Date: 3/30/2012 Req'd Qty: 16.00 **\*16\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo 1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs 3-Form Joggle on brake using Jig as per Dwg D3793	0.00 0.00				(18)			
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(16)			
150 <b>*150*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 10h05 FINISH TIME: 10h35 OVEN TEMPERATURE: 320°F	0.00 0.00				16	(DP)	12/04/03	m117338

W/O:		WORK ORDER CHANGES					
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**Work Order ID 82171**

Friday, March 23, 2012 1:29:23 PM

**\*82171\***

Page 3

Item ID: D3793-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Wearshoe

Start Date: 3/23/2012 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

16 PL 12-4-3

170

Identify as per dwg & Stock Location: FR-1

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

16 PL 12-4-3

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MLJ 12/04/03

12-04-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, March 23, 2012 1:29:27 PM

Work Order ID: 82171

**\*82171\***

Parent Item: D3793-1

**\*D3793-1\***

Parent Item Name: Wearshoe

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

161.1609

0.5902

9.940211

\*\*

*M* 12/04/02

**\*M304S20GA\***

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

161.160922

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

46.144422

B# 12/192

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	82/71
<b>Description: Wearshoe</b>		<b>Part Number:</b>	D3793-1
<b>Inspection Dwg: D3793 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.189	✓		VERN	HB-02
0.300 x 0.300	+/-0.010	0.301 x 0.307	✓		VERN	HB-02
1.885	+/-0.010	1.889	✓		VERN	HB-02
2.000	+/-0.010	2.000	✓		VERN	HB-02
5.00	+/-0.030	4.997	✓		VERN	HB-02
8.00	+/-0.030	7.998	✓		VERN	HB-02
14.00	+/-0.030	14.00	✓		MT	HB-07
20.00	+/-0.030	20.00	✓		MT	HB-07
14.066	+/-0.010	14.066	✓		MT	HB-07
18.983	+/-0.010	18.983	✓		MT	HB-07
23.900	+/-0.010	23.900	✓		MT	HB-07
27.400	+/-0.010	27.400	✓		MT	HB-07
29.400	+/-0.010	29.400	✓		MT	HB-07
32.900	+/-0.010	32.900	✓		MT	HB-07
0.040	+/-0.010	0.039	✓		VERN	HB-02

<b>Measured by:</b> JM / m/h	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12.04.02	<b>Date:</b> 12/04/02	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

094

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

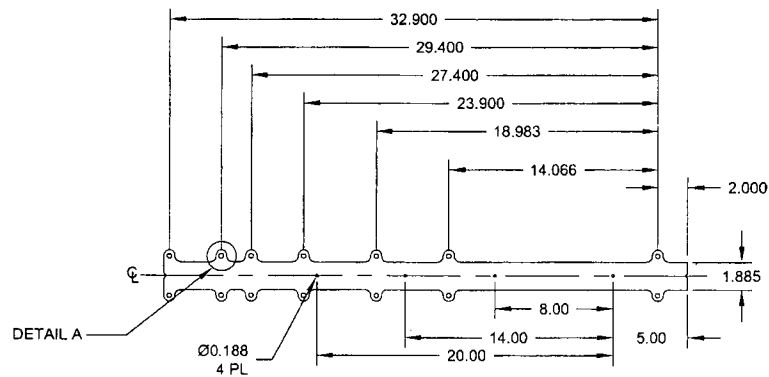
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

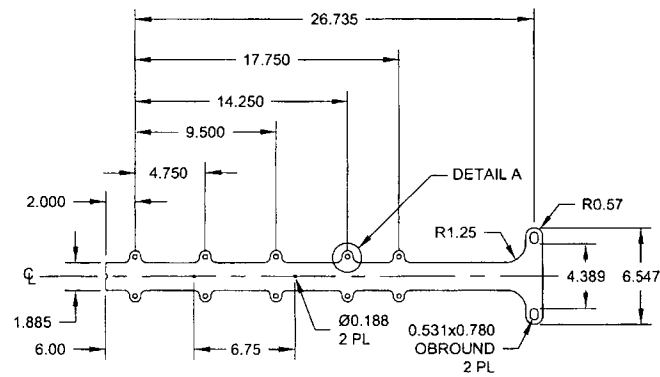
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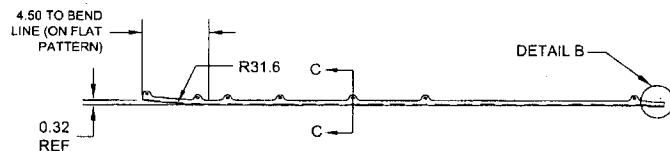
8 7 6 5 4 3 2 1



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 82171

R11-03-20

**RELEASED**  
08.05.14

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.5) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE	PH	08.05.14
DESIGN	PH	BY	DATE
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA  
DRAWING NO. D3793  
TITLE WEARSHOE  
REV. A  
SHEET 1 OF 2  
SCALE  
NTS  
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# Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

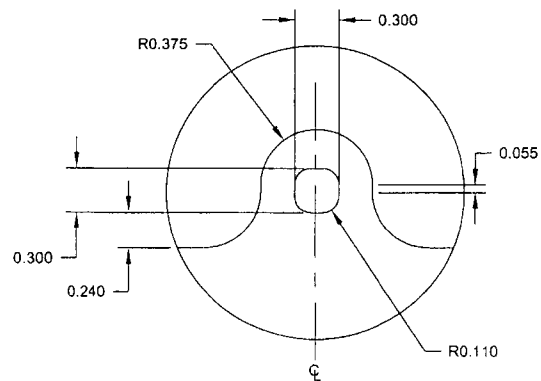
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

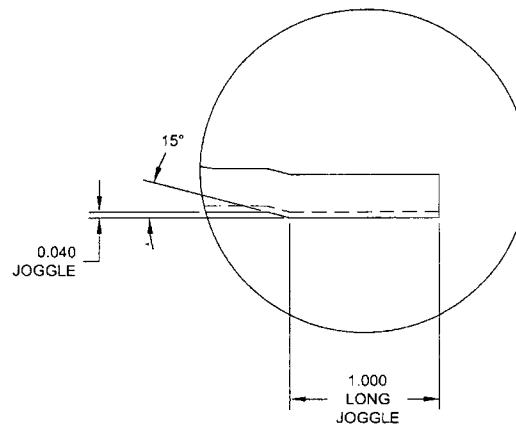
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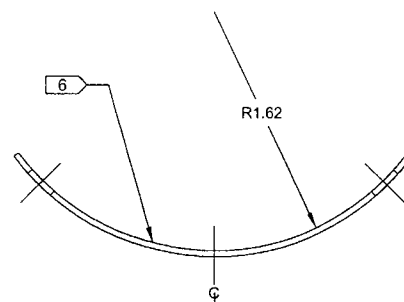
8 7 6 5 4 3 2 1



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

8217

**RELEASED**  
08-05-23

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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